distribute of

ilk, y

											DQA:	Date:	·
NCR: Y	es/	/ No				WORK ORDER NON-O	CO	NFOR	MANCE / UPI	DATE			
									•		QA Closed:	Date:	
Work Orde	or:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	,
Part N	-					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	-1	Water Jet d. Eng. Coor re/Packaging	Engineering Quality Other
NCR N	No.					Work Order Update	<u> </u>	1110111	Large Fab	Composite]	Supplier	
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling			ļ]		
Operator			ł										
Material													
Setup									1				
Other]										
Process							1						
Supplier													
Training			1										
Unapproved			1										
						F	AU	LT CATE	GORY				
Landi	ng G	Gear				General							
		Bending			. "	Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Work Ordo April-30-13 2:3		1091	- 	*101	1091*							Page 2
Item ID: Revision ID: Item Name:	D4061-1 Ski Cushion			Accept	*N900	040	100)*	Setup	Start Stop	1 71	S1* S2*
Start Date: Required Date: Reference:	4/25/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item l	ID:					I	
Approvals:	Process Pla	in:	Date:	-		ate:		I	Run	Start Stop		R1* R2*
Sequence ID/ Work Center I 120 *120* QC Quality Control		Operation Description QC8- Inspect parts - secon		Set Up/ Run Hours 0.00	Tool ID	Tool#		Accept Qty	Rej Qty		Reject Number	Insp. Stamp
130 *130* Packaging Packaging		Identify as per dwg & Sto	ock Location: <u>ST4</u> 5	0.00 0.00				20 x	<u> </u>	Ŋ	1, 10	13-06-6

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

*14**0***

Quality Control

13/6/10 4

213-06-7

NCR: Ye	s / No				WORK ORDER NON-	CONFO	RMA	NCE / UP	DATE			
					*					QA Closed:	Date	• •
Work Order	:				DISPOSITION				AGAINST I	DEPARTMENT	/PROCESS	
Part No	 D.				Rework Scrap			l-tube hining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR No					Use-as-is Work Order Update	Th	ermofo	~⊢—	Finishing Composite	— i	re/Packaging Supplier	Other
NCR IN	J			<u>_</u>	work Order Opdate	.	Lais	se rau	Composite		Jupplier [ا لـا
Root				Descri	ption of work order update	Initia	ı	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng	Desc	ription	Date	Verification	QC Inspector
oc/Data	_											
quip/Tooling			İ							1		
perator							1					· .
/laterial										,		
etup	_	İ										
Other							1					
rocess												
upplier	_]				İ						
raining	_	1										
Inapproved												
					F	AULT CA	ATEGOR	<u>Y</u>				
Landin	g Gear			_	General							7
L	Bending			_	Bend	Gra	in			Ovalized	L	Pressure/Forced
L	Centre N	ot Conce	ntric to (o/s	BOM/Route	Hard	dware			Over/Under	tolerance	Temperature/Cure
L	Cracks				Broken/Damaged	Insp	ection I	ncomplete	<u> </u>	Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	inst	ructions	Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
L	Cuffs				Contamination	Mai	intenan	ce		Part Moved		
L	Heat Trea	at			Cóuntersink	Misl	labeled]	Positioned V	Vrong	_
	Inspectio	n Strip in	Tube		Cut Too Short	Misi	read			Power Loss/	Surge	Other
	Ripples in	n Bend		. [Drill Holes	Offs	et		_			
Γ	Torque V	Vaves in I	Extrusio	n [Drawing	Out	of Calib	ration				
Ī	Turning S	Sequence			Finish	Out	of Sequ	ence				
	Wave/Tv	vist in Tul	be		Folio	Out	side Dim	ensions				

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-30-13 2:39:56 PM

Work Order ID:

101091

Parent Item:

D4061-1

Parent Item Name:

Ski Cushion

Start Date: 4/25/13

Required Date: 4/30/13

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV:A NEW ISSUE JLM 10-02-18 VERIFIED BY:EC

IPP REV:B 11.01.10 AS PER

DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			100	f	48.4000	0.4125	8.68421			

UHMW U-Channel

Location	Loc Qty	Loc Code	
ST202	6.4	₹ .	9,39
91102	6.4		
ST209a	42		
97824	42		

JUS 13/04/05

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CON	IFORM	MANCE / UPDA				
					Y					QA Closed:	Date:	
Work Orde	, pêr				DISPOSITION				AGAINST DEF	PARTMENT	/PROCESS	
	lo	`			Rework Scrap Use-as-is Work Order Update		Thern	Machining noforming	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	lı	nitial	Action	n	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		<u> </u>		·								
Operator												
Material												
Setup												
Other		ļ		i							•	
Process												,
Supplier												
Training		ł										
Unapproved		<u> </u>	<u> </u>									
					F	AUL'	T CATE	GORY				
Landi	ng Gear				General				_			-
	Bending			L	Bend	Ш	Grain			Ovalized	·	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Ш	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	ct	Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unc	clear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat Trea	at		Ţ.	Countersink		Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

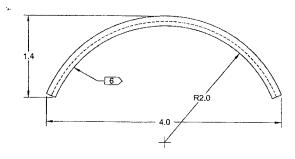
DART AEROSPACE LTD	Work Order:	101091
Description: Ski Cushion	Part Number:	D4061-1
Inspection Dwg: D4061 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

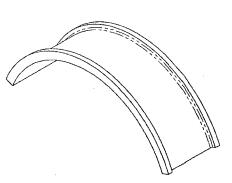
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.95	+/-0.030	4,935			1418-04	Veru
0.17	+/-0.030	0.182	Vi		111	111
1.050	+/-0.010	0,182 1,049 0,097 0,088 1,248	/		///	111
0.10	+/-0.030	0.097	V		7.1.2	, , ,
0.076	+0.015/-0.000	0.088	w/		4 7 C	, 11
1.25	+/-0.030	1. 148			/ 11	111
s						
1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1						
		,				
	, :					

Measured by:	RIP	Audited by:) <u>/</u>	Preliminary Approval:	
Date:	13/06/05	Date:	13-6-5	Date:	

Rev	Date	Change	Revised by	Δ	Approved
Α	11.02.11	New Issue	KJ	秋	1 &
***************************************	·			T	

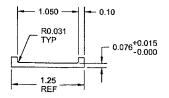


<u>D4061-1 412 SKI CUSHION</u>
(MAKE FROM D4061-1F)



0.17 ~

® D4061-1F FLAT MACHINED STATE



В	COSTS	: PART NOW N	ERIAL TO REDUCE MANUFACTURING MACHINED FLAT AND SHAPED WITH REF: PAR10-29.	мв	10.12.07		
Α	NEW IS	SUE		МВ	10.03.31		
REV.			DESCRIPTION	BY	. DATE		
DESIG	4	13	DART AEROSPA	CFI	TD		
DRAW	1	1	HAWKESBURY, ONTARI				
CHECK	ED	Se	DRAWING NO.		- REV. B		
MFG. A	PPR.	Ro	□ D4061		SHEET 1 OF 1		
APPRO	VED	Mad	TITLE		SCALE		
DE APP	PR.	-#	7 412 SKI CUSHION				
DATE	10.1	2.07	COPYRIGHT © 2010 BY DART A THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED THAT THE LISTED FOR ANY DESCRIPTION OF COMMUNICATIONS.	ON THE EXPRES	IS CONDITION THAT IT IS		

NOTES:

1) MATERIAL: MAKE FROM D4287-3 (B)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4061-1" AND B/N "BXXXXX" PER QSI 044 6.1
7) WEIGHT: 0.02 lbs

С

В